

Date: Thursday, 13/11/2008 1:05:46 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001-Dart Helicopters Services			Drawing Name	: OUTSIDE WASHER		
Job Number	: 43416			Part Number	: D32335		
Estimate Number	: 11154			Drawing Number	: D3233 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 13/11/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: MACHINED PARTS	Due Date	: 02/12/2008	Qty:	10
Previous Run	: 37647			Um:	Each		
Written By	:						
Checked & Approved By	: <u>JL 08-11-14</u>						
Comment	: Est. A 05.03.14 New issue KJ/JLM						
	Est Rev:B Now on Doosan Lathe 08-04-01 JLM Verified by:EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1020TR1875W250	ROUND TUBE 1.875 x .250w
Comment: Qty.: 0.1860 f(s)/Unit Total : 1.8596 f(s) 1020-1025 Round Tube Material: AISI 1020-1025 Seamless Round Tubing Cold Drawn per MIL-T-5066 or ASTM A513-00 MT1020 SRA or AMS 5075 or AMS 5077 (M1020TR1.875W.250) Identify for D3233-5 Batch: <u>102210</u>		
2.0	DOOSAN LATHE	DOOSAN LATHE
Comment: Doosan Lathe		
1- Turn as per Folio FA736 Rev: <u>N/A</u> & Dwg D3233 Rev: <u>B</u>		
2-Deburr per dwg D3233		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 13/11/2008 1:05:46 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTSIDE WASHER

Job Number: 43416

Part Number: D32335

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: STY83

PS/14/24 (10)

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



10/08.12.04

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3233	SHEET 2 OF 3

DATE

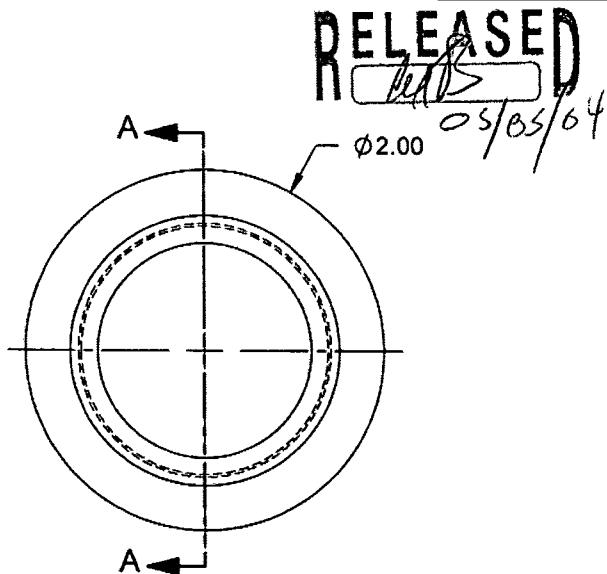
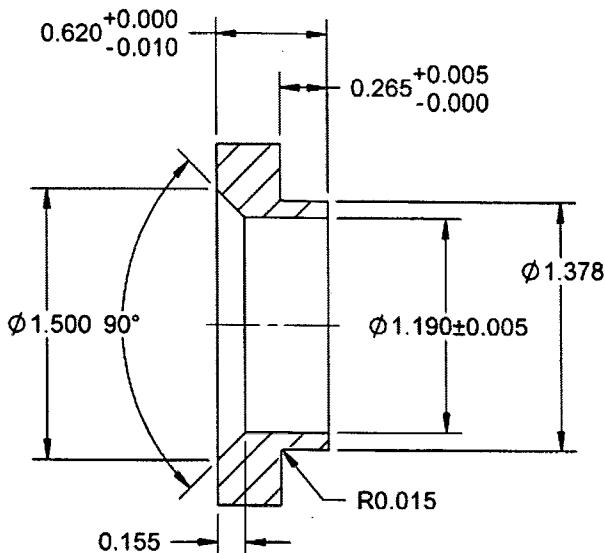
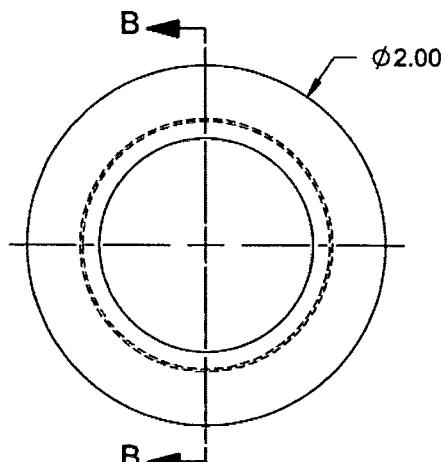
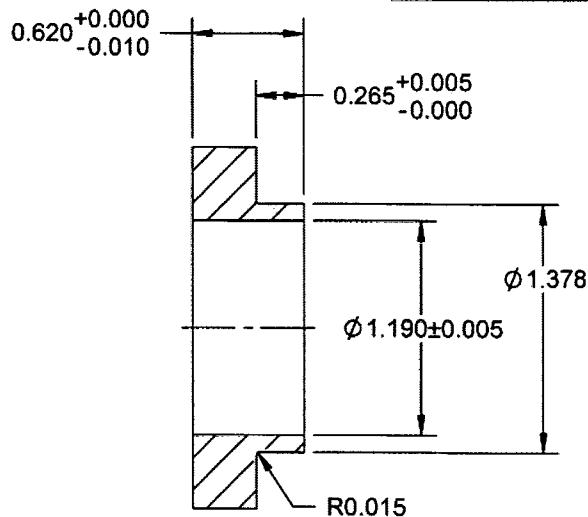
05.03.08

TITLE

WHEEL ASSEMBLY

SCALE

1:1

**SECTION A-A****D3233-1 INSIDE WASHER****SECTION B-B****D3233-3 OUTSIDE WASHER****NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 CONTROLLED COPY
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS
(REF. DART SPEC. M1020TR)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

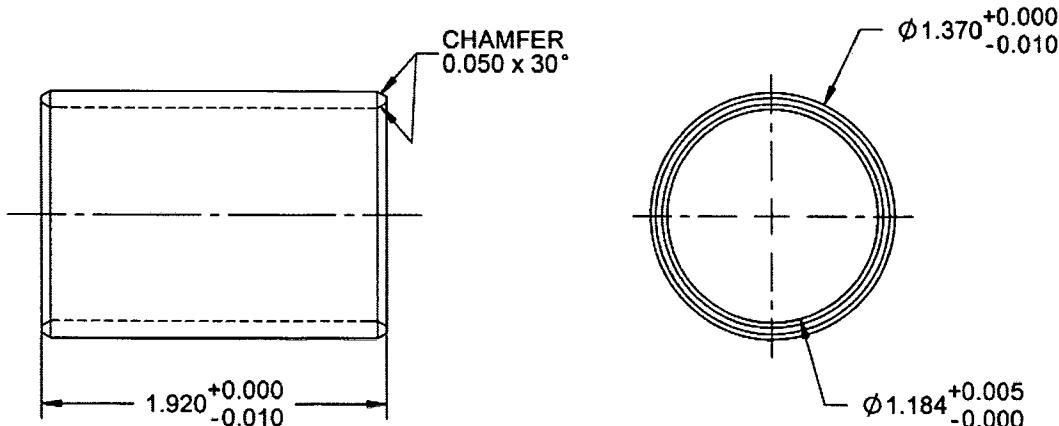
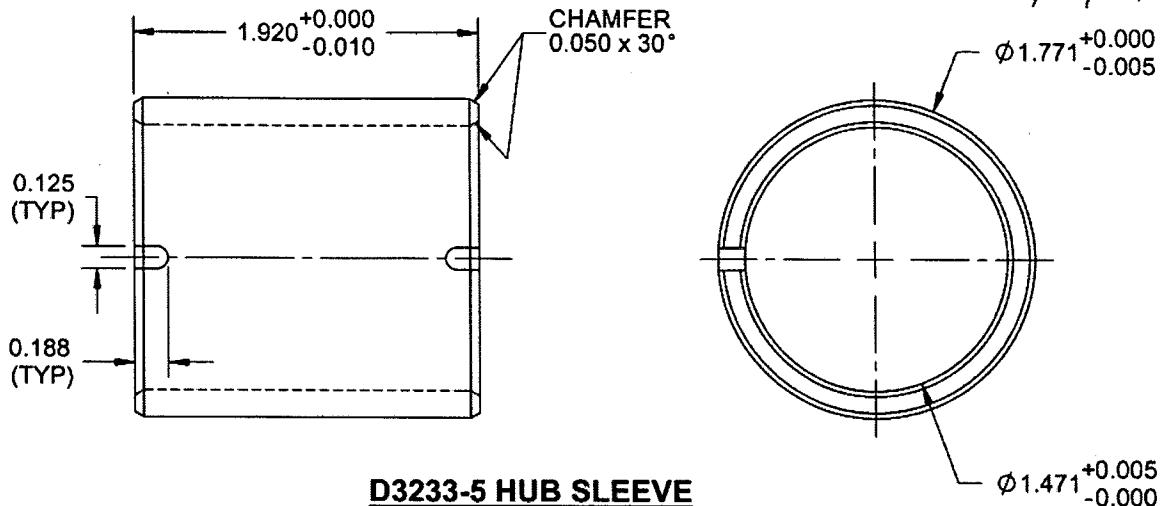
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WORK ORDER
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DART

DESIGN <i>3</i>	DRAWN BY <i>3</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PF</i>	APPROVED <i>WPS</i>	DRAWING NO. D3233	REV. B	SHEET 3 OF 3
DATE 05.03.08	TITLE WHEEL ASSEMBLY	SCALE 1:1		

RELEASED
WPS
05/05/04**D3233-7 SHAFT SLEEVE****NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS
(REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

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SUBJECT TO AMENDMENT
NO 43418

DART AEROSPACE LTD	Work Order:	43626
Description: D82335	Part Number:	
Inspection Dwg:	Rev: 15	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<i>RL</i>	Audited by:	<i>JL</i>	Prototype Approval:	N/A
Date:	<i>08/12/23</i>	Date:	<i>08/12/23</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	